

Work Order ID 1246170350-591-311

\*124617\*

Page 1

September-18-14 7:39:36 AM

B124617

Item ID: D350-591-311

BBB-B

Accept

\*N9000040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Heli-Access-Step™ LH

Start Date: 9/18/14 Start Qty: 10.00

\*10\*

Cust Item ID:

Required Date: 9/26/14 Req'd Qty: 10.00

\*10\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3272

Rev B

100

Document Control

0.00

\*100\*

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

110

0.00

\*110\*

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/RAluminum Rod B128956

3-Grind End Plate flush

DAS

38

9-89/14-10-14

10x CC 14-9-19

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**\*124617\***

Page 2

Item ID: D350-591-311

Accept

Revision ID:

**\*N900040100\***

Setup Start

**\*NS1\***

Item Name: Heli-Access-Step™ LH

Stop

**\*NS2\***

Start Date: 9/18/14 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 9/26/14 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

**\*120\***

QC

Memo

0.00

Quality Control

SEP 22 2014

10

DAS  
24  
9-89

130

QC5- Inspect part completeness to step on W/O

0.00

**\*130\***

QC

Memo

0.00

Quality Control

SEP 22 2014

10

DAS  
24  
9-89

140

Chemical Conversion Coat per QSI005 4.1

0.00

**\*140\***

HandFinish

Memo

0.00

Hand Finishing

10 4-09-25 DMC

**Work Order ID 124617**

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Page 3

Item ID: D350-591-311

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID: \*

Item Name: Heli-Access-Step™ LH

Stop **\*NS2\***

Start Date: 9/18/14 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 9/26/14 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC7-Inspect Chemical Conversion Coat

0.00

**\*150\***

QC

Memo

0.00

Quality Control

10 7/15 14-9-25

180

Large Fab

0.00

**\*180\***

Large Fab

Memo

0.00

Large Fab

10x CC 14-9-29DMC  
14-09-29

- 1-Assemble Leg Assembly as per Dwg D3272.

- 2-Leave one rivet out until welding is complete.

- 3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272  
A/RAluminum Rod 8128956

6-Grind End Plate flush

7-Install last rivet as per Dwg.

DMC  
14-09-30

**Work Order ID 124617****\*124617\***

Page 4

Item ID: D350-591-311

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Heli-Access-Step™ LH

Stop **\*NS2\***

Start Date: 9/18/14 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 9/26/14 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 <b>*190*</b> QC Quality Control	QC10- Inspect visual per QSI004- ground welds  Memo	0.00  0.00				<u>10</u>		DAS 9 9-89	DAS 38 9-89 14-10-01
200 <b>*200*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00				<u>10</u>		DAS 9 9-89	DAS 38 9-89 14-10-01
210 <b>*210*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00				<u>10</u>			<u>2614-10-2</u>

# Work Order ID 124617

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Item ID: D350-591-311

Accept

**\*N900040100\***

Setup

Start

**\*NS1\***

Revision ID:

Item Name: Heli-Access-Step™ LH

Stop

**\*NS2\***

Start Date: 9/18/14 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 9/26/14 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

**\*220\***

Powdercoat

*M 129808*

*10 0 14-10-2 DAS 34 9-89*

Powder Coating

Memo

0.00

START TIME: *1:10*

OVEN TEMPERATURE: *320°*

FINISH TIME: *1:40*

230

Wing Walk as per dwg QSI005 4.4 Batch *M1130204*

0.00

**\*230\***

HandFinish

Memo

0.00

Hand Finishing

*x10WH 4 11 11005*

240

QC3- Inspect Part Finish

0.00

**\*240\***

QC

Memo

0.00

Quality Control

*(10) DAS 38 9-89 14-10-7*

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**\*124617\***

Item ID: D350-591-311

Accept

**\*N900040100\***

Setup Start

Revision ID:

Stop

Item Name: Heli-Access-Step™ LH

Start Date: 9/18/14

Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 9/26/14

Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
Numb

250

Pick Kit

0.00

**\*250\***

Packaging

Memo

0.00

Packaging

10X 8/14/10-7

260

QC4- 100% Inspect kits for completeness

0.00

**\*260\***

QC

Memo

0.00

Quality Control

(10)

DAS  
38

9-89/4-10-14

270

Packaging

0.00

**\*270\***

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-591-311

Location: 10/1

10

DAS  
06  
9-89

09.15.2014

**Work Order ID 124617****\*124617\***

Page 7

Item ID: D350-591-311

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Heli-Access-Step™ LH

Stop **\*NS2\***

Start Date: 9/18/14 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 9/26/14 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

280

QC21- Final Inspection - Work Order Release

0.00

**\*280\***

QC

Memo

0.00

Quality Control

14/10/15 JJ

ME  
14-10-15

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Work Order ID: 124617

**\*124617\***

Parent Item: D350-591-311

**\*D350-591-311\***

Parent Item Name: Heli-Access-Step™ LH

Start Date: 9/18/14

Required Date: 9/26/14

Start Qty: 10.00

Required Qty: 10.00

## Comments:

IPP Rev:A04.03.22New issue KJ/RF

IPP Rev:B 07-06-09 Added D3272-1 JLM

IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified

by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3272-1

Manufactured No

110

Each

24.0000

1

10

**\*D3272-1\***

Step

\*\*

DMC 14-09-18

### Location

### Loc Qty

### Loc Code

WA003

24

115406

4

122259

10

124550

10

D3067-1

Manufactured No

110

Each

322.0000

1

10

**\*D3067-1\***

End Plate

\*\*

CC 14-9-18

### Location

### Loc Qty

### Loc Code

WA003

322

101785

67

102686

14

117776

91

119290

150

D3219-1

Manufactured No

110

Each

73.0000

2

20

**\*D3219-1\***

Plate

\*\*

CC 14-9-18

### Location

### Loc Qty

### Loc Code

WA003

73

114934

8

115339

65

20x



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Page 2

Work Order ID: 124617

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step™ LH

**\*124617\***

**\*D350-591-311\***

Start Date: 9/18/14

Required Date: 9/26/14

Start Qty: 10.00

Required Qty: 10.00

D3066-1

Manufactured No

180

Each

84.0000

2

20

**\*D3066-1\***

Spacer

**\*\***

DMC 14-09-29

Location

Loc Qty

Loc Code

WA003

84

106302

3

115867

2

115868

39

115869

40

20

MS20600-AD4W4

Purchased

No

180

Each

2,041.000

16

160

**\*MS20600-AD4W4\***

Rivets

**\*\***

DMC 14-09-29

Location

Loc Qty

Loc Code

ST310

2041

125577

215

M128899

1826

160

D3065-041

Manufactured

No

180

Each

32.0000

1

10

**\*D3065-041\***

Step Leg Assembly

**\*\***

DMC 14-09-29

Location

Loc Qty

Loc Code

WA003

32

102830

6

109447

2

113075

2

121478

20

123378

2

10

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Page 2

# Picklist Print

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Work Order ID: 124617

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step™ LH

**\*124617\***

**\*D350-591-311\***

Start Date: 9/18/14

Required Date: 9/26/14

Start Qty: 10.00

Required Qty: 10.00

D3067-1

Manufactured No

180

Each

322.0000

1

10

**\*D3067-1\***

End Plate

\*\*

CC 14-9-29

Location

Loc Qty

Loc Code

WA003

322

101785

67

102686

14

117776

91

119290

150

AN3-35A

Purchased

No

250

Each

53.0000

2

20

**\*AN3-35A\***

Bolt

DAS

38

9-89

\*\*

DAS

26

9-89



Location

Loc Qty

Loc Code

FG

10

122800

10

ST348

43

m129934

43

D3235-1

Manufactured

No

250

Each

263.0000

2

20

**\*D3235-1\***

Mounting Lug

\*\*

DAS

26

9-89



OCT 08 2014

DAS

38

9-89

Location

Loc Qty

Loc Code

ST519

263

102818

4

105939

17

108670

43

114441

46

116383

100

116384

3

116385

50

2x  
8x

10x

September-18-14 7:39:35 AM

Shop Packet Print

Page 3

# Picklist Print

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Page 4

Work Order ID: 124617

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step™ LH

**\*124617\***

**\*D350-591-311\***

Start Date: 9/18/14

Required Date: 9/26/14

Start Qty: 10.00

Required Qty: 10.00

D3278-041

Manufactured No

250

Each

59.0000

10

**\*D3278-041\***

DAS  
38  
9-89

\*\*

DAS  
26  
9-89

Support Assembly

Location

Loc Qty

Loc Code

ST521

29

102349

1

114169

27

114940

1

ST523

30

123337

30

NAS1149D0463J

Purchased

No

250

Each

4,662.000

16

160

**\*NAS1149D0463J\***

WASHER

DAS  
38  
9-89

\*\*

DAS  
26  
9-89

DAS  
06  
9-89

OCT 08 2014

Location

Loc Qty

Loc Code

CA

485

M129682

485

ST277

4177

113706

1

16941

8

M126221

20

M127813

6

M127904

16

M128591

44

M128995

1500

M129390

2582

OCT 10 2014

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Page 5

Work Order ID: 124617

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step™ LH

**\*124617\***

**\*D350-591-311\***

Start Date: 9/18/14

Required Date: 9/26/14

Start Qty: 10.00

Required Qty: 10.00

NAS1149D0563J

Purchased

No

250

Each

1,719.000

4 40

**\*NAS1149D0563J\***

Washer

DAS  
38  
9-89

Location

Loc Qty

Loc Code

GA

125

m125807

125

ST510a

1594

m126319

98

m128257

1496

250

Each

111.0000

2 20

AN5-36A

Purchased

No

**\*AN5-36A\***

Bolt

DAS  
38  
9-89

Location

Loc Qty

Loc Code

ST336

111

M126105

1

M127410

7

M127460

3

M130325

100

250

Each

131.0000

2 20

D2618

Manufactured

No

**\*D2618\***

Bushing

DAS  
38  
-89

Location

Loc Qty

Loc Code

ST008A

131

103863

3

114872

1

123045

100

97780

27

DAS  
26  
9-89

DAS  
26  
9-89

DAS  
26  
9-89

DAS  
26  
9-89

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Page 5

# Picklist Print

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Page 6

Work Order ID: 124617

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step™ LH

\*124617\*

\*D350-591-311\*

Start Date: 9/18/14

Required Date: 9/26/14

Start Qty: 10.00

Required Qty: 10.00

D2230-3

Manufactured No

250 Each

278.0000

4 40

\*\*

DAS  
26  
9-89

\*D2230-3\*

Mounting Lug

DAS  
38  
9-89

Location

Loc Qty

Loc Code

FG

7

109344

4

89045

3

ST519

271

108668

1

109344

2

114151

1

114921

4

115583

20

116378

143

116379

100

D2856-400

Manufactured No

250

f

184.0000

1:2 12

\*\*

DAS  
26  
9-89

\*D2856-400\*

Abrasion Strip 4" Wide (Per Foot)

DAS  
38  
9-89

Location

Loc Qty

Loc Code

ST426

184

117887

184

\*\*\* cut (2) at 7.20" (D2856-400-720) \*\*\*

MS21042L3

Purchased

No

250

Each

2,521.000

2 20

\*\*

DAS  
26  
9-89

OCT 08 2014

\*MS21042L3\*

Nut

DAS  
38  
9-89

Location

Loc Qty

Loc Code

ST307

2521

123900

934

M127410

11

M127831

41

M128401

42

M128754

1493

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# Picklist Print

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Work Order ID: 124617

**\*124617\***

Parent Item: D350-591-311

**\*D350-591-311\***

Parent Item Name: Heli-Access-Step™ LH

Start Date: 9/18/14

Required Date: 9/26/14

Start Qty: 10.00

Required Qty: 10.00

AN4-13A

Purchased

No

250

Each

630.0000

8 80

**\*AN4-13A\***

DAS

38

9-89

Bolt

\*\*

DAS  
26  
9-89

DAS  
26  
9-89

Location

Loc Qty

Loc Code

CA

2

m129682

2

FG

20

122808

20

GA

14

m125709

14

ST345

400

m130325

400

ST515

194

121652

4

m127432

36

m127817

22

m128739

132

80x

DAS  
26  
9-89

MS21042L5

Purchased

No

250

Each

1,148.000

2 20

**\*MS21042L5\***

DAS

38

9-89

Nut

\*\*

DAS  
26  
9-89

OCT 08 2014

Location

Loc Qty

Loc Code

ST307

1148

125684

8

m127304

1

m127813

497

m128810

7

m129472

35

m130358

600

20x

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Work Order ID: 124617

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step™ LH

**\*124617\***

**\*D350-591-311\***

Start Date: 9/18/14

Required Date: 9/26/14

Start Qty: 10.00

Required Qty: 10.00

MS21042L4

Purchased

No

250

Each

3,953.000

8 80

**\*MS21042L4\***

Locknut

DAS  
38  
9-89

Location

Loc Qty

Loc Code

ST007

12

121444

12

ST307

3941

111827

2

126275

5

m126015

12

m126275

27

m127255

63

m127376

9

m127813

831

m128300

69

m128798

663

m129472

760

m129934

1500

NAS1149D0363J

Purchased

No

250

Each

2,382.000

4 40

**\*NAS1149D0363J\***

Washer

DAS  
38  
9-89

DAS  
38  
9-89

Location

Loc Qty

Loc Code

GA

7

124392

7

ST276

1005

m123441

5

m130358

1000

ST510a

1370

m128429

1370

DAS  
26  
9-89

DAS  
26  
9-89

DAS  
26  
9-89

OCT 08 2014

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Shop Packet Print

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DESIGN <i>GP</i>	DRAWN BY <i>B</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07.06.04 *ff*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

△  
B

**GENERAL NOTES:**

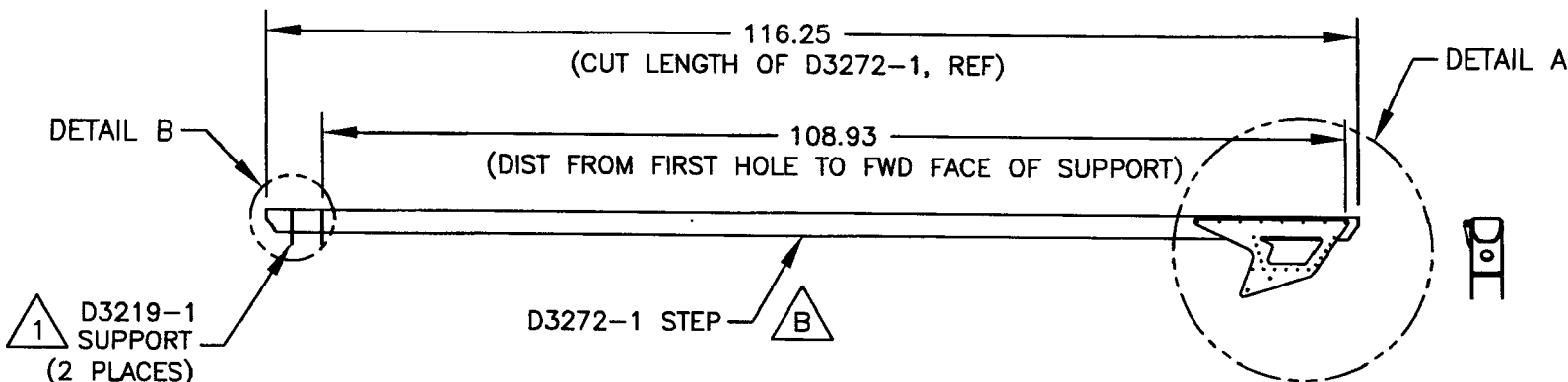
- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

*also refer to D3272*

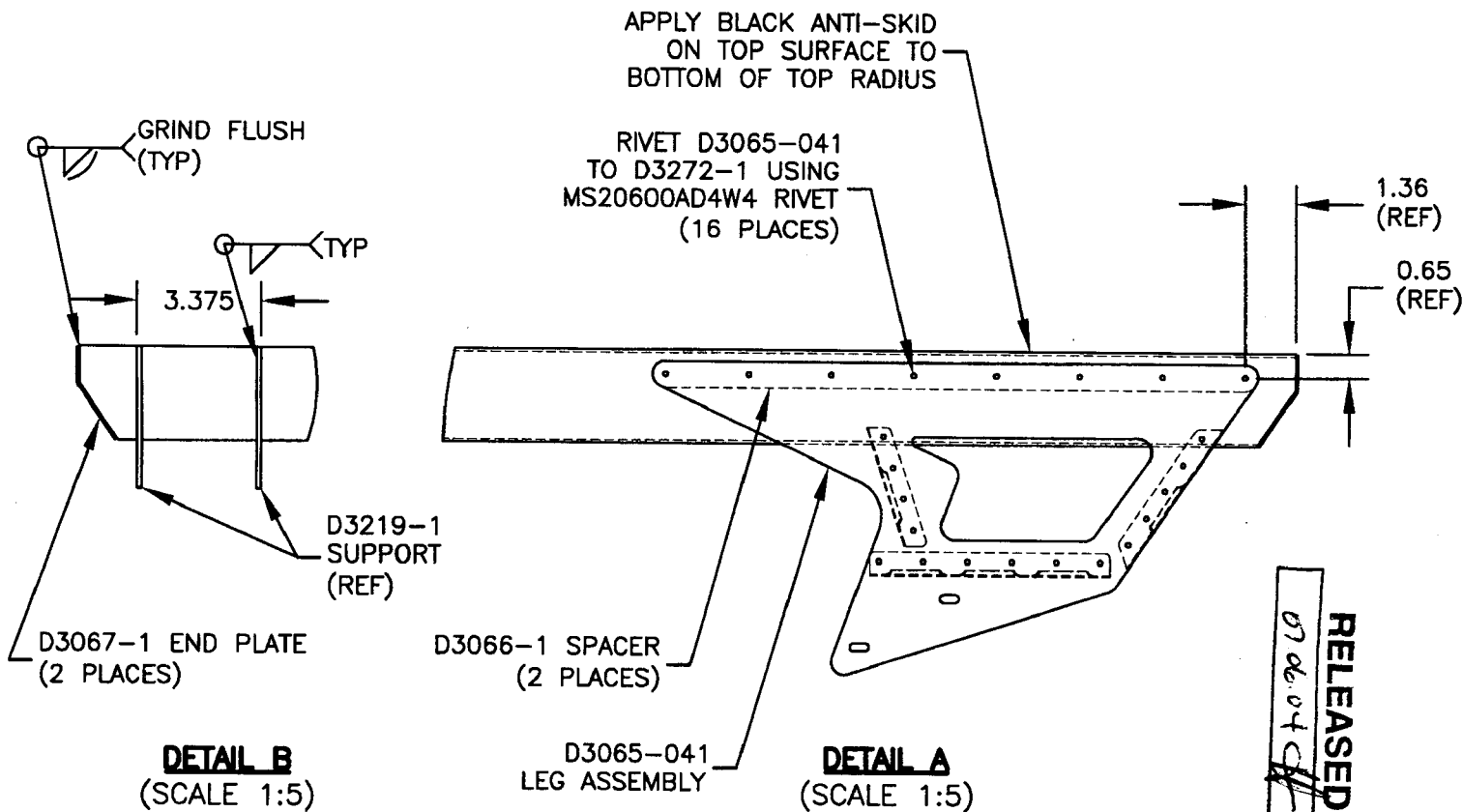
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**D3272-041 STEP ASSEMBLY (LH. SHOWN)**  
**D3272-042 STEP ASSEMBLY (RH, OPPOSITE)**



RELEASED  
07.05.18

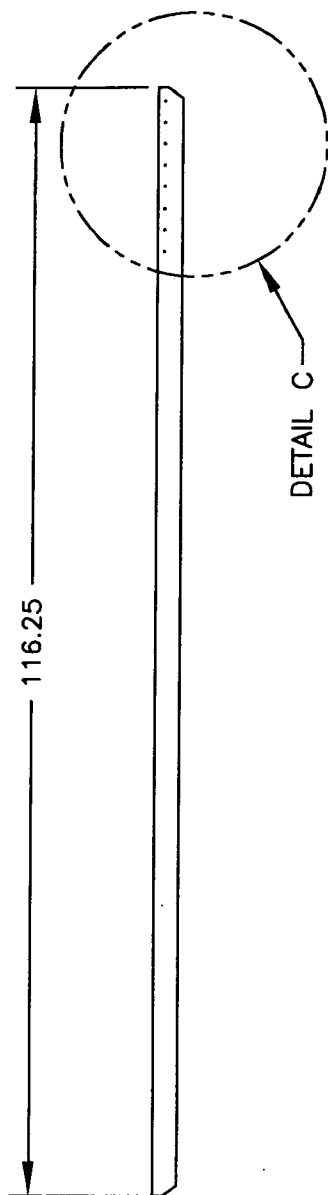
DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>CE</i>	APPROVED <i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE 07.05.18	DRAWING NO. D3272	REV. B
	TITLE STEP ASSEMBLY, HI LONG	SHEET 2 OF 3
		SCALE 1:20



DESIGN <i>GP</i>	DRAWN BY <i>JB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

RELEASED

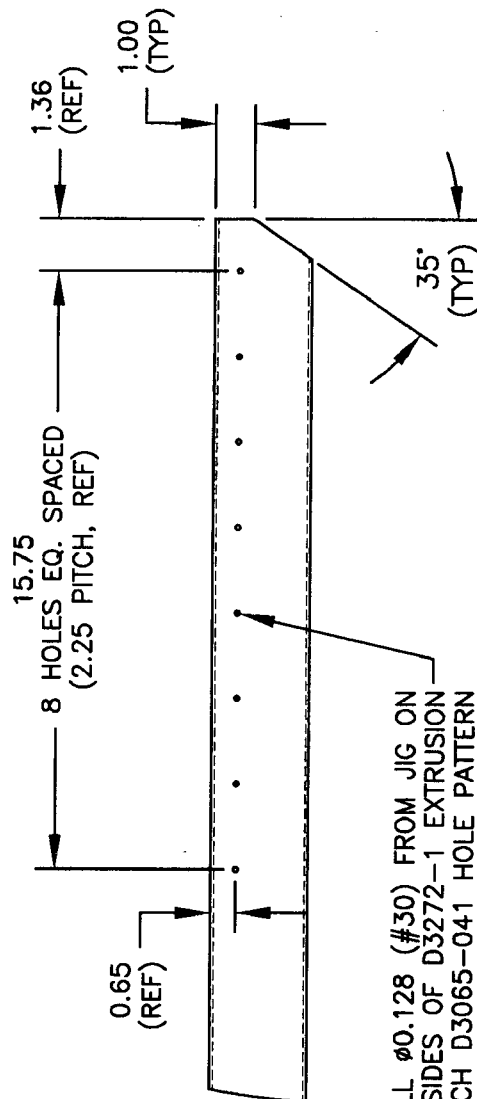
07.06.04 *[Signature]*



DETAIL C

**B** D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL  $\phi 0.128$  (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

**C** DETAIL C  
(SCALE 1:5)

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Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™, Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™, Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
				X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
					X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	IBUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	DSI 9410-011	STEP MODIFICATION KIT

\*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

Work Order ID: 124617D350-591-311

\*124617\*

Page 1

September-18-14 7:39:36 AM

B124617

Item ID: D350-591-311

BEB-B

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Heli-Access-Step™ LH

Start Date: 9/18/14 Start Qty: 10.00

\*10\*

Cust Item ID:

Required Date: 9/26/14 Req'd Qty: 10.00

\*10\*

Customer:

Reference:

Run Start

\*NR1\*

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

\*NR2\*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3272	Rev B								
100	Document Control	0.00							
*100*	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and type labels as per PPP D350-591-311 CHG001								
110		0.00							
*110*	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Bevel end for welding FWD ONLY								
	2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272								
	A/RAluminum Rod B128956								
	3-Grind End Plate flush								

10x CC 14-9-19